

Work Order ID 122378

122378

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July-15-14 9:02:51 AM

Item ID: D4681-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web Assembly
 Start Date: 7/15/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/18/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4681	B								

110 0.00
110
 Skidtubes Memo 0.00
 Skidtubes 1- CUT TO LENGHT AS PER DWG

14-7-15

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

14/07/20 1 0

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
121		0.00							
121									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FB186								
	DWG REV: <u>B</u>								
	FOLIO REV: <u>AA</u>								
	DEBURR								
122	QC2- Inspect parts off machine FAI/FAIB	0.00							
122									
QC	Memo	0.00							
Quality Control									
123	QC8- Inspect parts - second check	0.00							
123									
QC	Memo	0.00							
Quality Control									

DAS
44
9-89

14/07/21

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Item ID: D4681-041 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 7/18/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							DGL 14-7-21
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							DP 14-7-21
Quality Control									
150		0.00							
150									
Skidtubes	Memo	0.00							DP 14-8-14
Skidtubes	INSTALL DOUBLER BY REVITING AND SEALING FAYING SURFACE WITH PROSEAL AS PER DWG A/R PROSEAL: <u>128638</u> EXP: 14-10-30								

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Item ID: D4681-041 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 7/15/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/18/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1	0	BE 14-08-14	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>46</u> Memo	0.00 0.00						DD 14-8-14	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						MLJ 14-08-15 MLJ 14-08-14	

Picklist Print

July-15-14 9:02:50 AM

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Work Order ID: 122378

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Parent Item: D4681-041

D4681-041

Parent Item Name: Web Assembly

Start Date: 7/15/14

Required Date: 7/18/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.15 NEW ISSUE DD VERF:JLM
REV:B 13.08.08 PB1 DD VERF:JLM
13.11.14 AS PER DWG REV.B DD VERF:JLM

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2963-125

Manufactured No

Each 89.0000

D2963-125

105 I Beam Extrusion

**

14-7-15

Location

Loc Qty

Loc Code

HALL

89

115870

66

28673

23

D4681-3

Manufactured No

Each 8.0000

D4681-3

Doubler

**

14-8-14

Location

Loc Qty

Loc Code

ST127

8

101097

4

101098

4

MS20470AD4-6

Purchased No

Each 4,383.000

MS20470AD4-6

RIVET

**

14-8-14

Location

Loc Qty

Loc Code

ST312

4383

118927

756

m128401

624

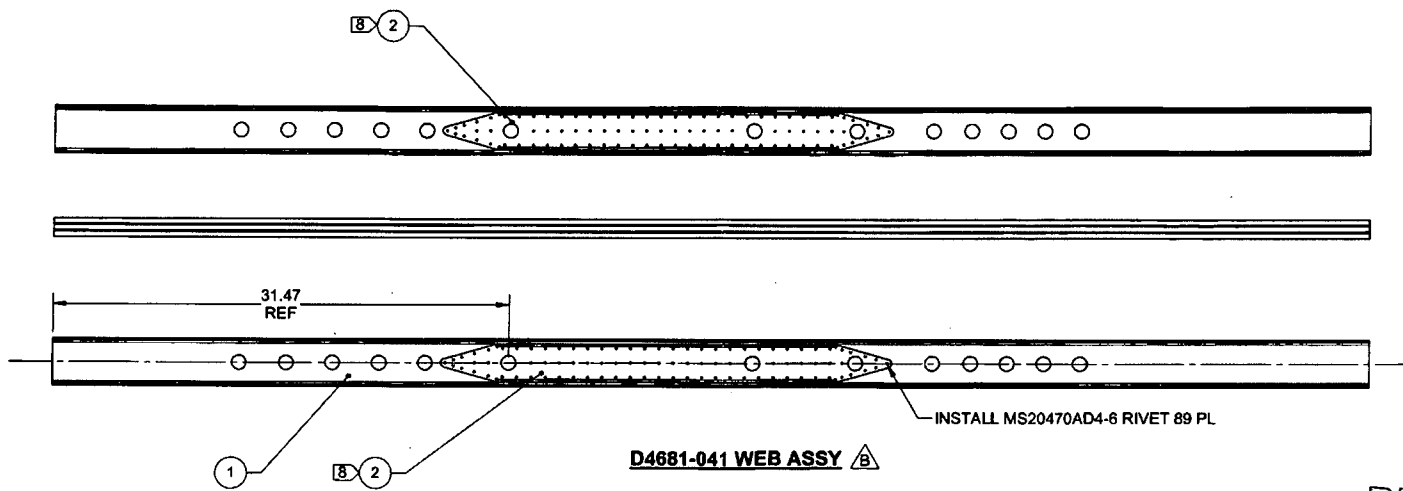
m128754

1488

m129499

1515

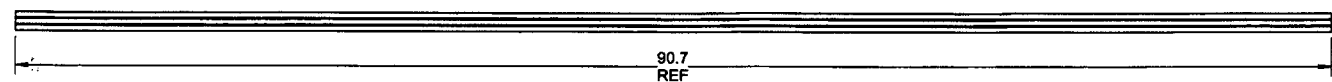
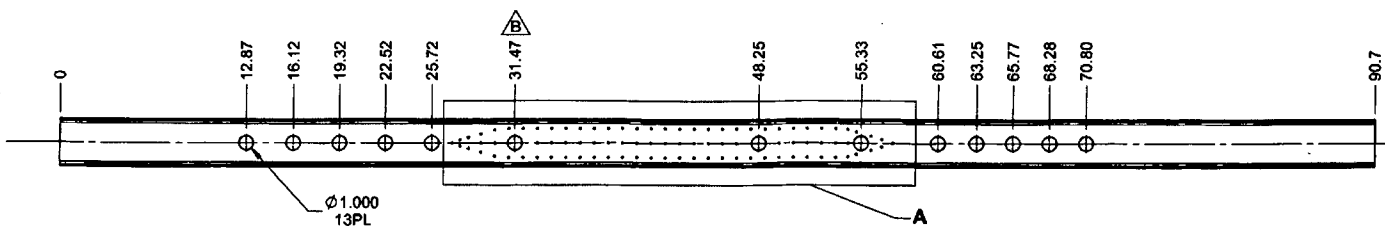
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4681-041	WEB ASSY
1	1	D4681-1	WEB
2	2	D4681-3	DOUBLER
3	89	MS20470AD4-6	RIVET, PAN HEAD



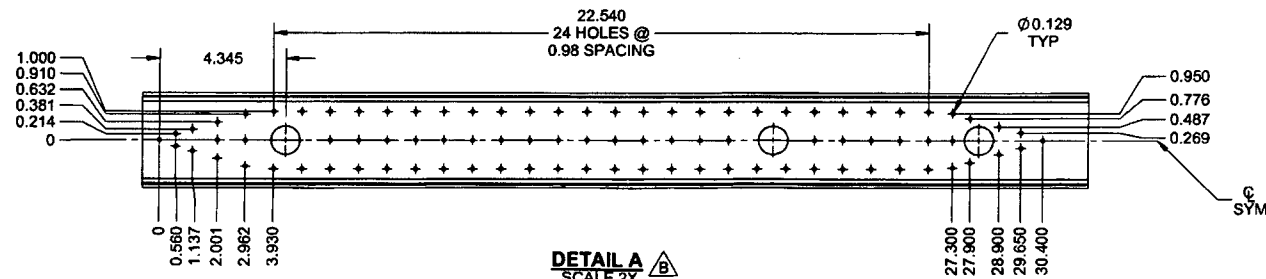
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4681-041" AND B/N PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 5.94 lbs
 - 8) SEAL FAYING SURFACES WITH PROSEAL P/S 890 B-1/2 (PRC)

B	MS20470AD4-6 WAS MS20470AD4-7, ADDED DETAIL A ON SHEET 2, VARIOUS DIMENSIONAL CHANGES.	AP	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	AP	D4681	SHEET 1 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEB ASSY	NTS
DATE	13.08.08	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2013-11-13
WJ



D4681-1 WEB



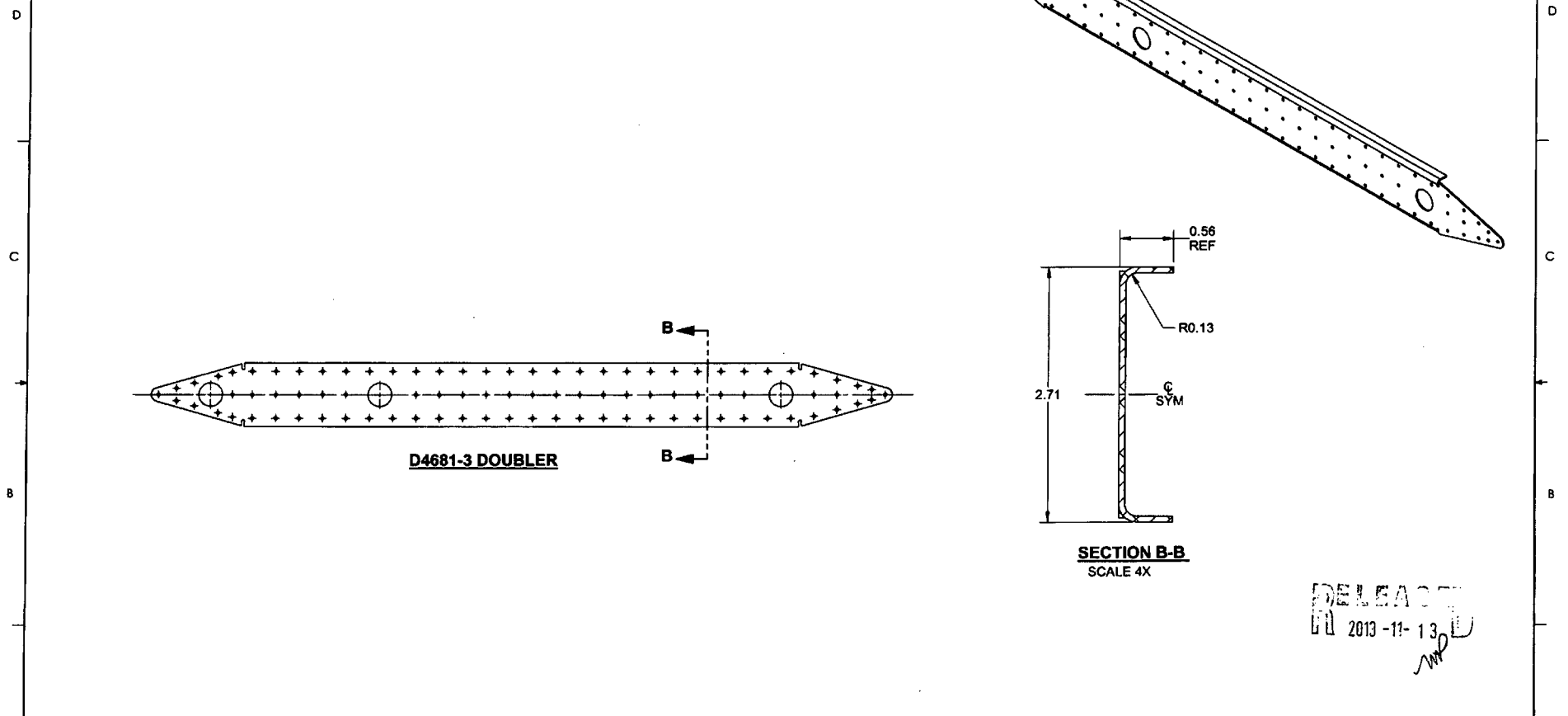
DETAIL A
SCALE 2X

RELEASED
2013-11-13

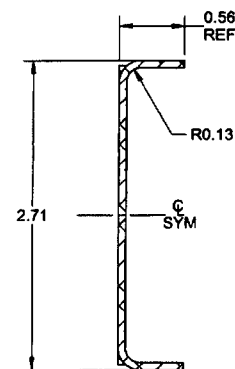
- NOTES:**
- 1) MATERIAL: MAKE FROM D2963-092 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.74 lbs

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
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8 7 6 5 4 3 2 1



D4681-3 DOUBLER



SECTION B-B
SCALE 4X

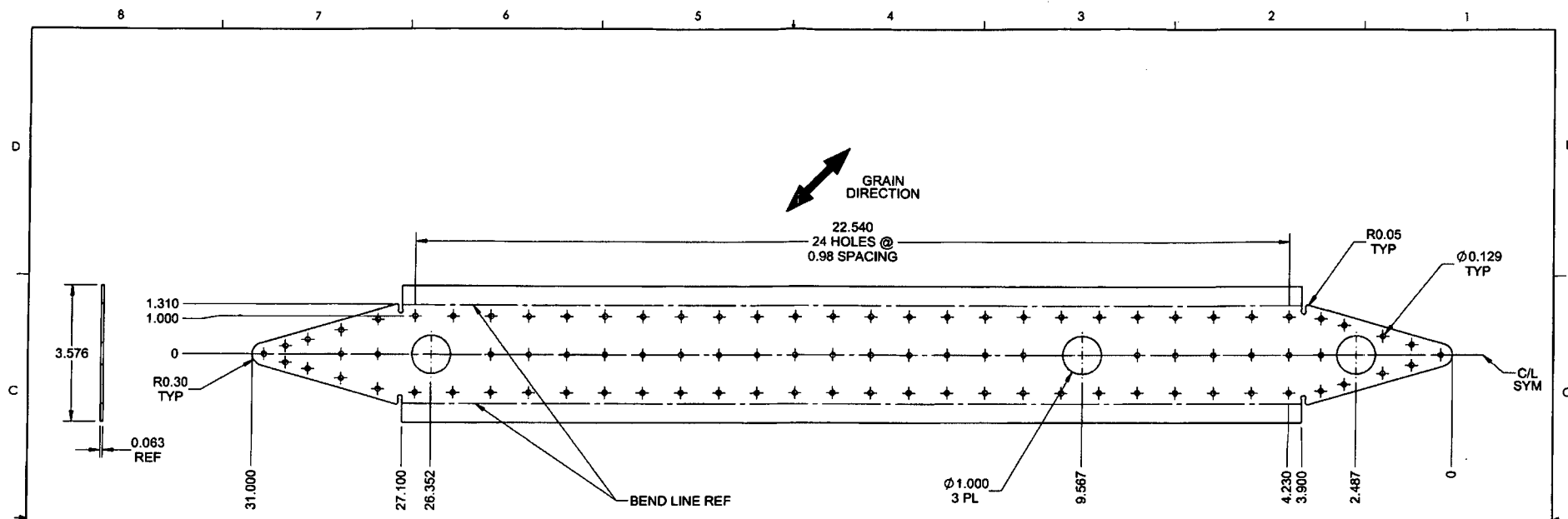
RELEASED
2013-11-13
JMD

NOTES:

- 1) MATERIAL: MAKE FROM D4681-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: .56 lbs

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8 7 6 5 4 3 2 1



D4681-3F DOUBLER
(FLAT PATTERN)

2013-11-13

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 SHEET 0.063 THK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC. M6061T6S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.56 lbs

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	8/	D4681	SHEET 4 OF 4
APPROVED	8/	TITLE	SCALE
DE APPR.	8/	WEB ASSY	NTS
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FIRST ARTICLE INSPECTION CHECKLIST

DAS

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	—